

**Work Order ID 81008**

Tuesday, March 06, 2012 1:43:10 PM

**\*81008\***

Page 1

Item ID: D4149-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Lug Plate. Aft

Start Date: 3/6/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12-03-06* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept  
Qty Reject  
Qty Reject  
Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D4149

C

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: *C*Dwg Rev: *C*

Deburr as required

*B12-3-8**(15)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*B12-3-8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81008**

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Item ID: D4149-1

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**\*N900040100\***Setup Start **\*NS1\***

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Stop **\*NS2\***

Start Date: 3/6/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

S.763/09

(45)

150

Identify as per dwg & Stock Location 133

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

12/3/9 15

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

MLJ 12/03/09

MLJ 12/03/09  
15

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 81008

Parent Item: D4149-1

Parent Item Name: Crosstube Lug Plate. Aft

Start Date: 3/6/2012

Required Date: 3/12/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	39.5000	0.1355	1.7115789			

Location

MAT020

120243

120604

Loc Qty

39.5

26

13.5

Loc Code

1812-3-8

120604

(18)

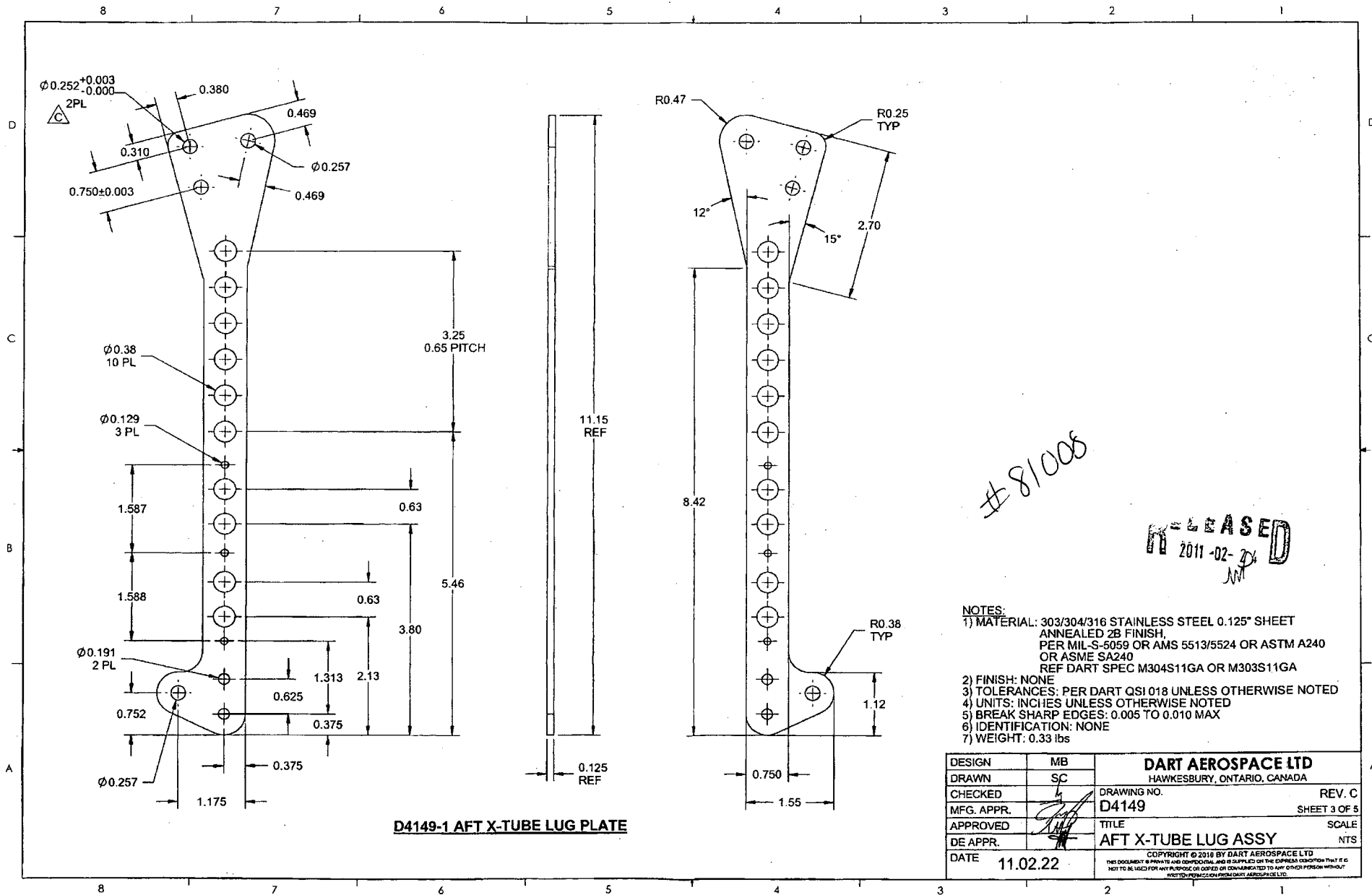
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 81604
<b>Description:</b> Aft Crosstube Lug Plate		<b>Part Number:</b> D4149-1
<b>Inspection Dwg:</b> D4149	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.128	2		V RBZ	
Ø0.191	+0.005/-0.001	.190	2		V	
Ø0.257	+0.006/-0.001	.257	2		V	
Ø0.38	+0.006/-0.001	.379	2		V	
0.380	+/-0.010	.383	2		V	
0.469	+/-0.010	.469	2		V	
0.310	+/-0.010	.310	2		V	
0.750	+/-0.010	.747	2		V	
3.25	+/-0.030	3.253	2		V	
0.65	+/-0.030	.648	2		V	
0.63	+/-0.030	.631	1		V	
5.46	+/-0.030	5.464	2		V	
3.80	+/-0.030	3.802	2		V	
2.13	+/-0.030	2.133	2		V	
1.313	+/-0.010	1.313	2		V	
0.625	+/-0.010	.623	2		V	
0.375	+/-0.010	.376	2		V	
1.175	+/-0.010	1.179	2		V	
0.752	+/-0.010	.752	2		V	
1.588	+/-0.010	1.589	2		V	
1.587	+/-0.010	1.589	2		V	
11.15	+/-0.030	11.152	2		P	
0.750	+/-0.010	.760	2		V	
1.55	+/-0.030	1.560	2		V	
1.12	+/-0.030	1.124	2		V	
8.42	+/-0.030	8.42	2		PROW302	
2.70	+/-0.030	2.70	2		V	
0.125	+/-0.010	.118	2		V	
Ø0.252	+0.003/-0.000	.252	2		V	

<b>Measured by:</b> RB	<b>Audited by:</b> J	<b>Preliminary Approval:</b>
<b>Date:</b> 12-3-8	<b>Date:</b> 12/03/09	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

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